



# FORTH ESTUARY TRANSPORT AUTHORITY

## L.P.I. WELD INSPECTION REPORT

Technician	Inspection Qualification:	Date. : 08/01/13.
Signature:	<b>P.C.N. LEVEL 2</b>	
Work Pack . : No.004. Workshop fabrication.	Drg No. : BC 08 11-04-09	Inspection Part. KINGPOST No. 34.
Inspection Document Conforming To BSEN 571-1:1997& BSEN1289:1998. Additional Info see FETA WP 15 &16		
Acceptance Standard:	BSEN 1289: 1998	
Acceptance Level:(Highlighted)	<b>1                      2                      3</b>	
Area Examined:(BSEN571-1)	Welds & Heat Affected Zone	
Process Type( Highlighted)	<b>Fluorescent                      Colour Contrast                      Combined</b>	
Type/Make of Consumables:	Rocol Flaw: Cleaner, Penetrant, Developer	
Method of Application:	Spraying/ <b>Brushing</b>	
Penetration Time:	20mins to 30mins	
Development Time:	15mins	
Surface Condition:	<b>As Welded</b> Dressed	
Surface Preparation:	Dry & free of all dirt, grease, scale, spatter, oil etc.	
Illumination:	<b>Natural</b> Auxiliary	
Fabrication Stage:	Fabrication Complete.	
Purpose of Test:	To find all surface breaking defects/ indications.	
Name of Welder:	I.D. No: <b>FE. 002.</b>	Results:
Sporadic areas of slight undercut evident. All welds inspected 100% both visually and by using the above method. All welds satisfactory.		<u>Accept:</u>  <b>YES</b>
		<u>Reject:</u>